

Work Order ID 92073

October-22-12 3:18:34 PM

92073

Page 1

Item ID: 647.1812

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Shim

Stop *NS2*

Start Date: 22/10/2012 **Start Qty:** 78.00

78

Cust Item ID:

Required Date: 05/11/2012 **Req'd Qty:** 78.00

78

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-10-22 Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

[illegible]

Work Order ID 92073

October-22-12 3:18:34 PM

92073

Page 2

Item ID: 647.1812

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Shim

Stop ***NS2***

Start Date: 22/10/2012 Start Qty: 78.00

78

Cust Item ID:

Required Date: 05/11/2012 Req'd Qty: 78.00

78

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours
15
9-89

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Outsource process-Anodize per QSI017 4.1.10.1

0.00

140

Outsource4

Memo

0.00

Outsource process - Anodize

ISSUE P/O: **18304**
HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.00

Packaging

78
can

12-11-01

12/11/12 (78)

Work Order ID 92073

October-22-12 3:18:34 PM

92073

Page 3

Item ID: 647.1812

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Shim

Stop ***NS2***

Start Date: 22/10/2012 Start Qty: 78.00

78

Cust Item ID:

Required Date: 05/11/2012 Req'd Qty: 78.00

78

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

78

DAS
05
8-83

12 11 07

170

0.00

170

SprayPaint

Memo

0.00

Spray Painting

PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2)

CARDINAL 4860-50 PRIMER BATCH: 122543

78

φ

φ

Ad

12-11-19

180

QC14- Inspect Spray Paint

0.00

180

QC

Memo

0.00

Quality Control

DAS

12/11/19

(out)

Work Order ID 92073

October-22-12 3:18:34 PM

92073

Page 4

Item ID: 647.1812

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Shim

Stop *NS2*

Start Date: 22/10/2012 Start Qty: 78.00

78

Cust Item ID:

Required Date: 05/11/2012 Req'd Qty: 78.00

78

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <i>SH/438</i>	0.00							
190									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

Per 4/21 *(38)*

12/11/22 *JD*

MF
12-11-21

Picklist Print

October-22-12 3:18:38 PM

Page 1

Work Order ID: 92073

92073

Parent Item: 647.1812

647 1812

Parent Item Name: Shim

Start Date: 22/10/2012

Required Date: 05/11/2012

Start Qty: 78.00

Required Qty: 78.00

Comments: IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

Purchased

No

110

sf

40.4700

0.017

1.395789

M2024T3S 063

**

1.4

June-11-1

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

40.47

119916

0.1

121197

16.32

123096

24.05

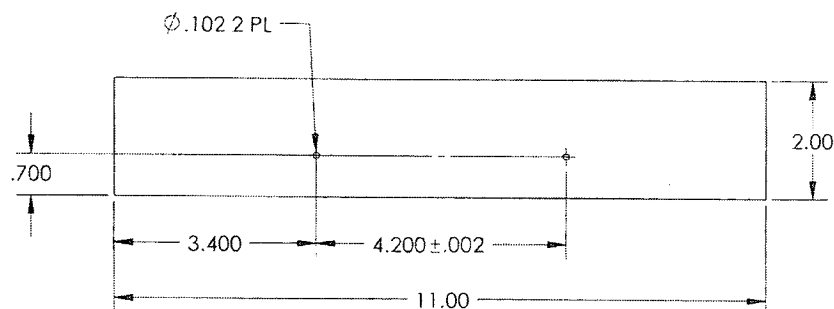
123096

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DATE	REV	BY	APP
11/11/10	1	J. L. L.	
11/11/10	2	J. L. L.	

NOTES:

1. MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120



647.1810

SHAW-WALKER
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITH NOTICE
WORK ORDER
NO. 920.73.MLS

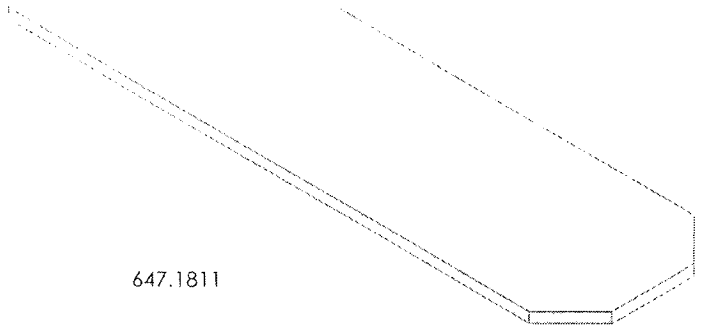
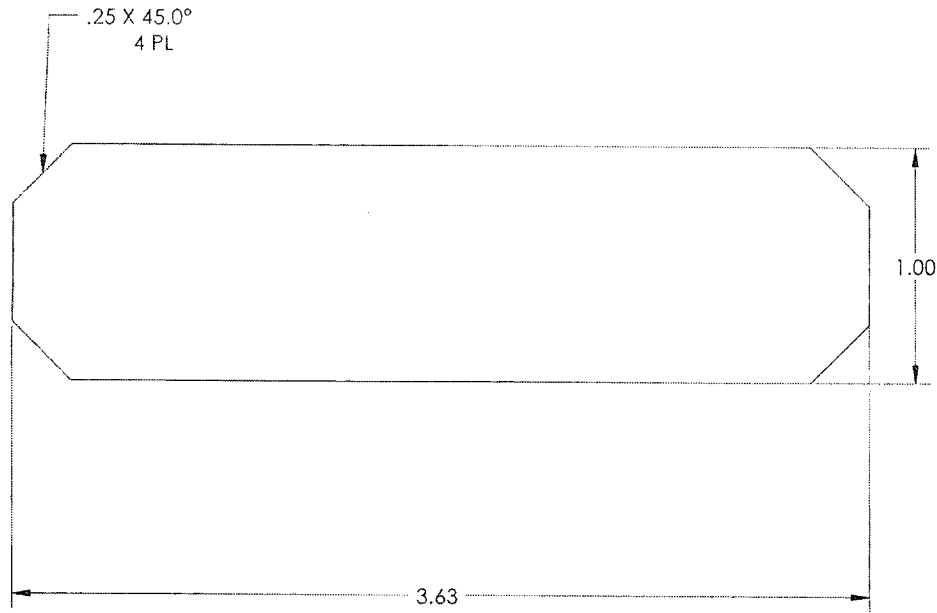
12-10-22

.063

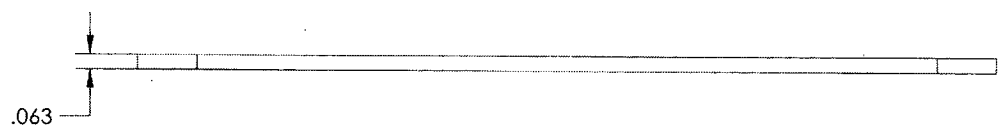
QTY	FIN D	PART #	DESCRIPTION	MATL	SPEC.
		647.1818	NOSE DOOR SPACER	AL	AL
		647.1817	SUPPORT, RH	AL	AL
		647.1816	SUPPORT, LH	AL	AL
		647.1815	GUSSET, RH	AL	AL
		647.1814	GUSSET, LH	AL	AL
		647.1813	ANGLE	AL	AL
		647.1812	SHIM	AL	AL
		647.1811	SPACER	AL	AL
		647.1810	NOSE DOOR DOUBLER	AL	AL
QTY	FIN D	PART #	DESCRIPTION	MATL	SPEC.
NEXT ASSY (S)		647.1300			
PARTS LIST					
APICAL INDUSTRIES					
2608 TEMPLE HEIGHTS DR.					
OCEANSIDE, CA. 92056-3512 (760)724-5300					
SHEETMETAL					
647.1800					
SCALE: NONE					
SHEET 1 OF 7					

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
 ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED
 ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED

92073



647.1811



ORIGINAL DATE 06/06/06		DRAWN BY 06/06/06	
CHECKED BY 06/06/06		APPROVED BY 06/06/06	
CONTRACT NO. 06/06/06		SHEET METAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE FRACTIONS DECIMALS ± .01 ANGLES ± .1°		SCALE: NONE	REV N/C

APICAL INDUSTRIES
 2608 TEMPLE HEIGHTS DR.
 OCEANSIDE, CA. 92056-3512 (760) 724-5300

647.1800

SHEET 2 OF 7

2

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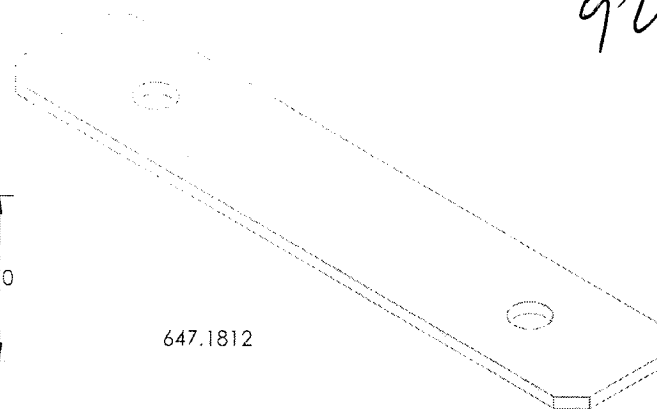
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92073

647.1812

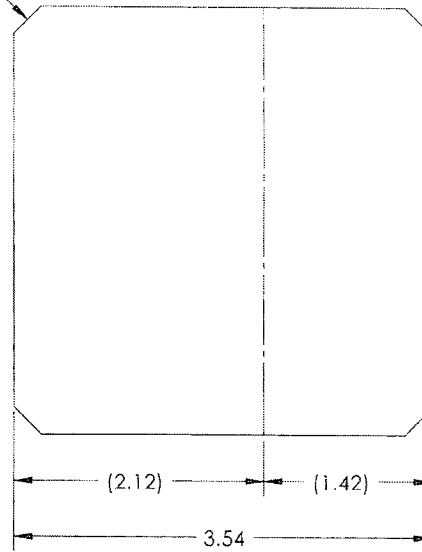
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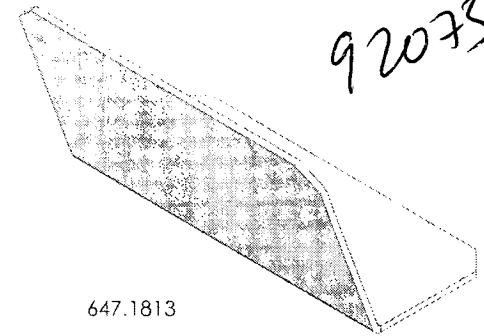
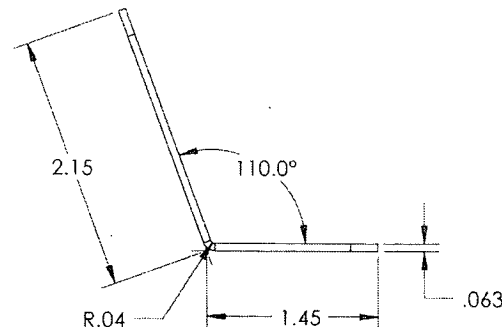
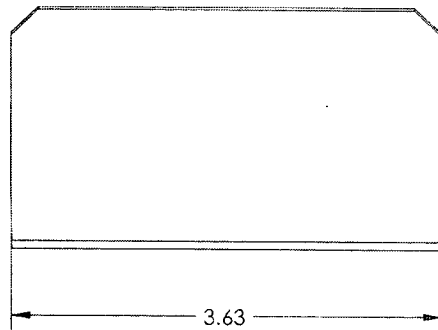
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ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
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 DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED

.23 X 45.0°
4 PL



FLAT PATTERN



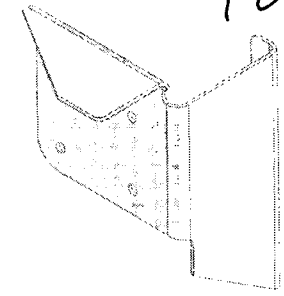
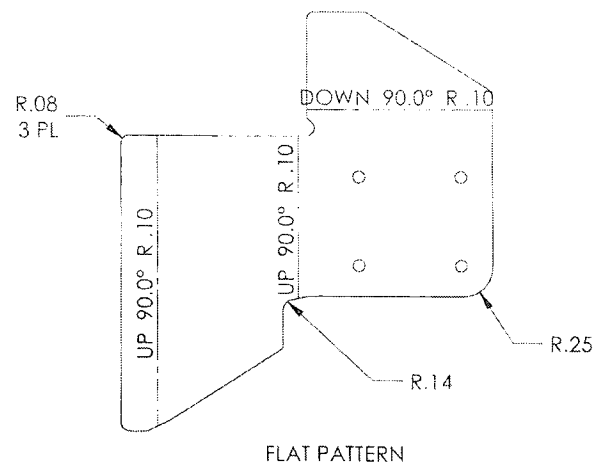
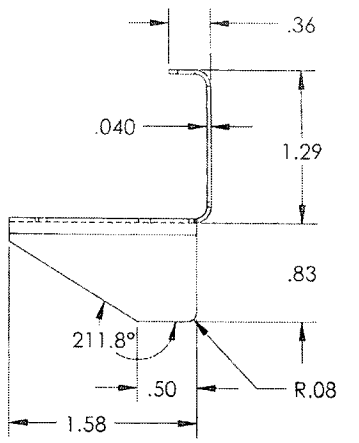
92073

647.1813

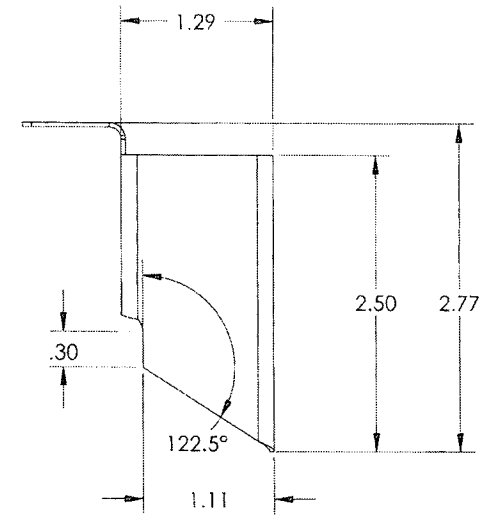
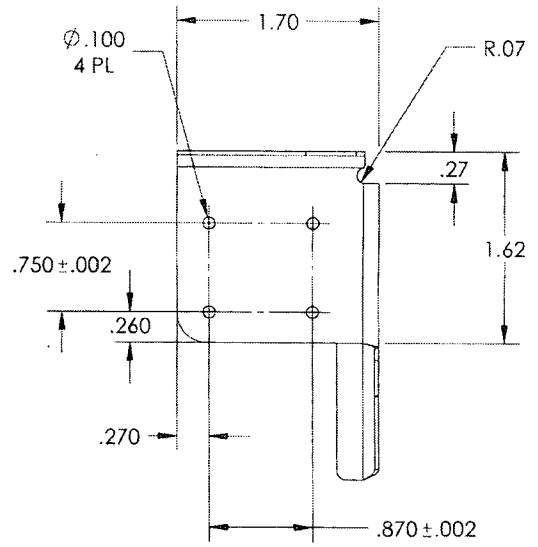
ORIGINAL DATE DWG BY: JPL DESIGN BY: JPL CHECKED BY: JPL DESIGNED BY: JPL DRAWING APPROVAL P. BRANCO DWG. NO. CO. BRANCH		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR OCEANSIDE, CA 92056-3512 (760) 724-5300		
		SHEETMETAL		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DIMENSIONS ARE DIMENSIONS ARE DIMENSIONS ARE DIMENSIONS ARE	REV	CASE CODE	DWG NO	REV
	B	07M26	647.1800	N/C
SCALE: NONE		SHEET 4 OF 7		

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
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92073

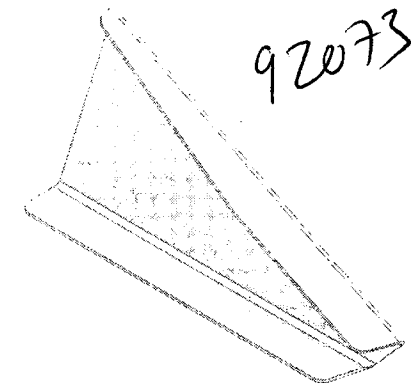
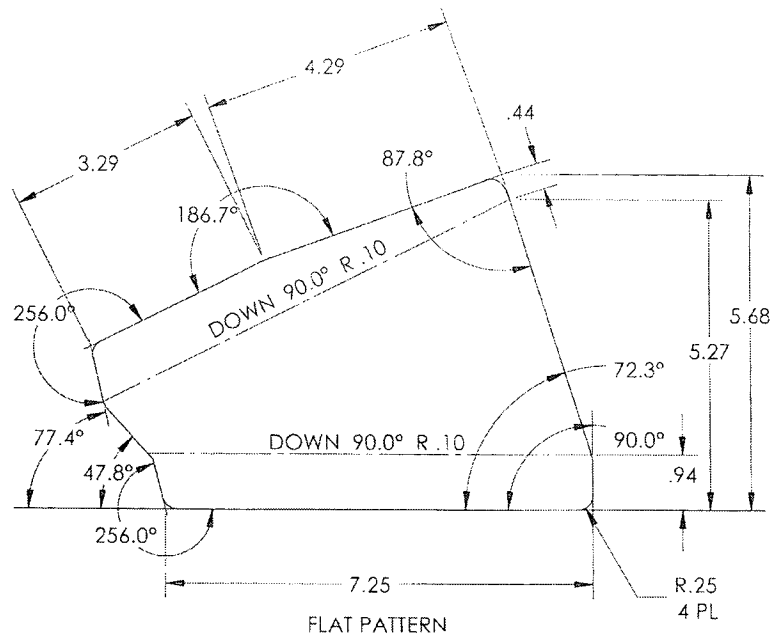
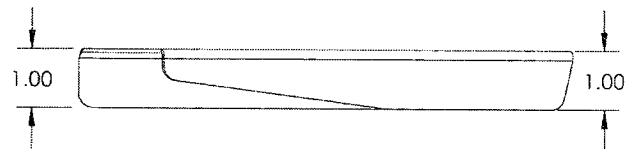


647.1814 SHOWN
 647.1815 OPPOSITE



ORIGINAL DATE: 06/04/01		APICAL INDUSTRIES	
DRAWN BY: J. G. H. / J. G. H.		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: J. G. H. / J. G. H.		OCEANSIDE, CA 92056-3512 (760) 724-5300	
DRAWING APPROVAL: J. G. H. / J. G. H.		SHEETMETAL	
REVISION: 1.0		SCALE: NONE	
CONTRACT NO: 647.1800		SHEET 5 OF 7	

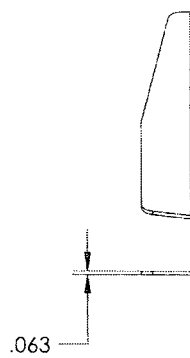
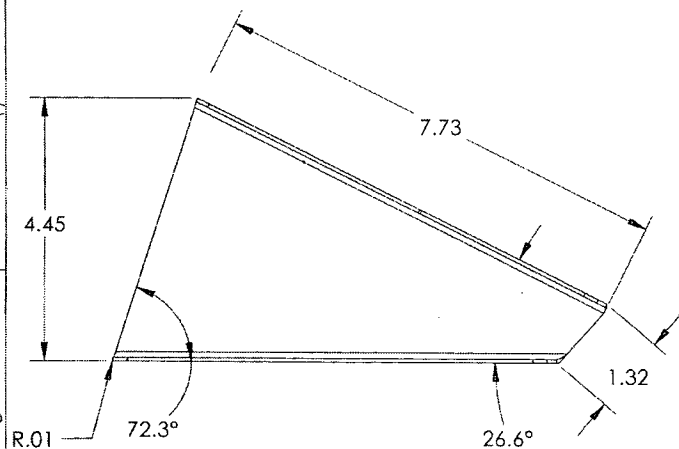
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2. DIMENSIONS ARE TO CENTERLINE UNLESS OTHERWISE SPECIFIED.
3. DIMENSIONS ARE TO EXTERIOR UNLESS OTHERWISE SPECIFIED.



92073

647.1816 SHOWN
647.1817 OPPOSITE

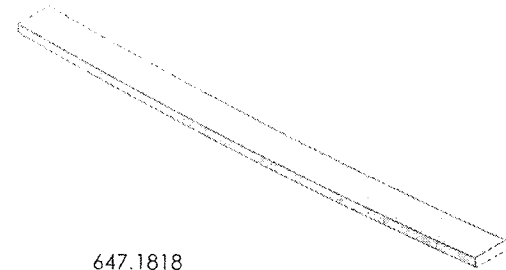
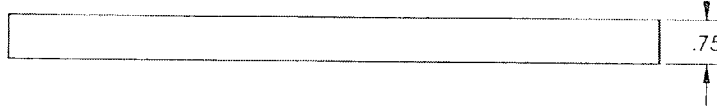
FLAT PATTERN



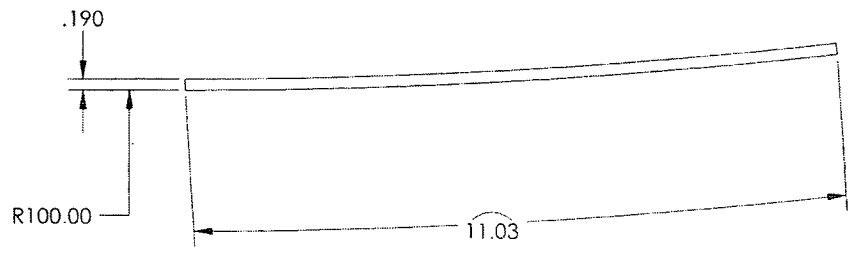
<small> STANDARD DATE (M/D-Y) 08-01-07 DRAWN BY: CHECKED L. CAMERON P. BRAY 28-000000 APPROVAL IN BRAY 000000 CONTRACT NO. </small>		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
<small> UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE FRACTIONS DECIMALS ±.01 ANGLES ±.5° </small>		SHEETMETAL 647.1800 SCALE: NONE	REV H/C SHEET 6 OF 7

IF THIS DRAWING IS BEING USED FOR THE CONSTRUCTION OF A BUILDING, THE USER SHALL BE RESPONSIBLE FOR OBTAINING ALL NECESSARY PERMITS AND FOR THE ACCURACY OF THE INFORMATION PROVIDED HEREON. THE USER SHALL BE RESPONSIBLE FOR THE PROTECTION OF THE INFORMATION PROVIDED HEREON.

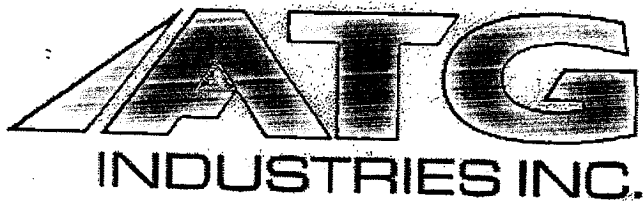
92073



647.1818



ORIGINAL DATE		2608 TEMPLE HEIGHTS DR.	
DRAWN BY		CCEANSIDE, CA 92056-3512 (760) 724-5300	
CHECKED BY		SHEETMETAL	
DESIGNED BY		647.1800	
DATE		N/C	
CONTRACT NO.		SCALE: NONE	
UNLESS OTHERWISE SPECIFIED		SHEET 7 OF 7	
DIMENSIONS ARE IN INCHES			
TOLERANCES ARE:			
FRACTIONS DECIMALS ± .01			
DIMENSIONS ± .01			
ANGLES ± .5°			



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62027

Date: 05-Nov-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST 10 PCS 646.9813 10 PCS 646.9811 10 PCS 646.9812 10 PCS 646.9812 2 PCS 646.9811 15 PCS 646.4711 15 PCS 647.4716 15 PCS 647.4712 15 PCS 647.4717 15 PCS 647.4714 15 PCS 647.4715 15 PCS 647.4718 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120674	Rev:	Line: <i>101214/7</i>
1 lot	Part: ASST 7 PCS 647.1810 14 PCS 647.1811 91 PCS 647.1812 2 PCS 647.1612 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120673	Rev:	Line: <i>PO: PO18304</i>
Certificate of Conformance			



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62027

Date: 05-Nov-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via
Quantity	Description	
	A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.	
	ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY	
	DATE: <u>5/12/12</u>	
	CERTIFIED SIGNATURE: <u><i>mv</i></u>	
	RECEIVER SIGNATURE: _____	